

Date: Thursday, 18/12/2008 12:51:33 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 44166	
Estimate Number : 13550	
P.O. Number :	Part Number : D32343
This Issue : 18/12/2008 S.O. No. :	Drawing Number : D3234 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/12/2008 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 43631	Material :
Written By :	Due Date : 05/01/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08-12-19</u>	
Comment : Est Rev:A New Issue 08-08-14 JLM Verified By:EC Est Rev:B 08-12-18 as per ECN08-582 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2273 sf(s)/Unit Total : 2.2733 sf(s)
 2024-T3 .050 sheet
 BATCH: 107711 IB 9-1-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3234
 Dwg Rev: B
 Prog Rev: B

IB 9-1-12

2-Deburr if necessary

IB 9-1-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09101112

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

IB

09-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D-3234-3 PAR #: N/A Fault Category: Prod. Inc. med. & Small NCR: (Yes) No DQA: ID Date: 09/11/23
 Resolution: DSI 4269-011 DS50-687-023 Scrap Disposition: Scrap QA: N/C Closed: ID Date: 09/10/23

NCR: <u>441166</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/2	#20	one part scrap Part moves while water jetting outside polic	<u>JB</u> <u>QSPR</u>	Scrap and Destroy and Reple Qty <u>(X)</u> <u>M# 107711</u>	<u>B</u> <u>9-1-12</u>	<u>S</u> <u>09/01/12</u>	<u>JB</u> <u>QSPR</u>	<u>S</u> <u>09/01/12</u>
		EC. Parts are placed too close together to place weights on. (Process)	<u>JB</u> <u>QSPR</u>				<u>JB</u> <u>QSPR</u>	<u>S</u> <u>09/01/12</u>

NOTE: Date & initial all entries

Date: Thursday, 18/12/2008 12:51:33 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44166

Part Number: D32343

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(11)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST182

09/01/20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 92.024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

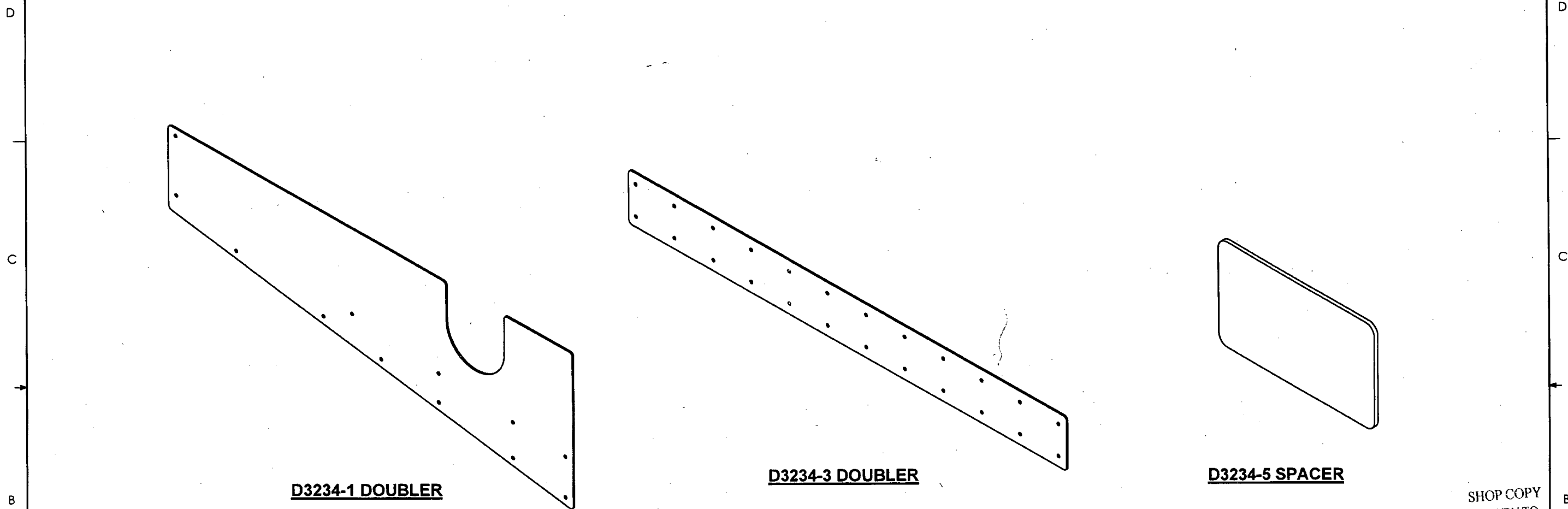
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3234-1 DOUBLER

D3234-3 DOUBLER

D3234-5 SPACER

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

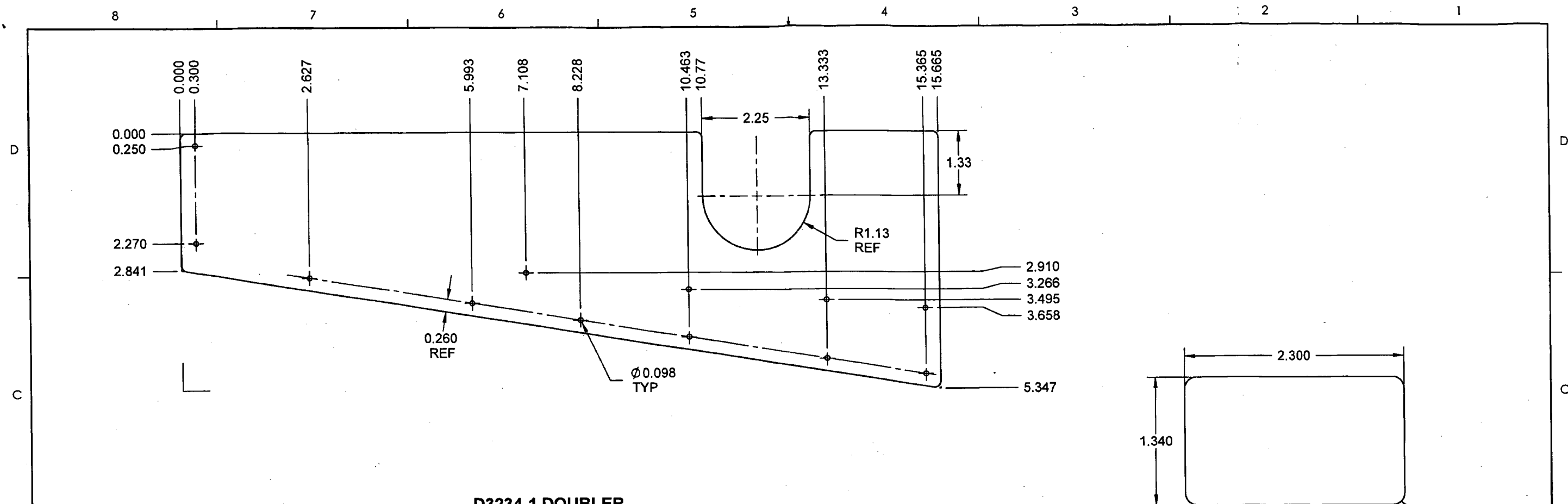
-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -1: 0.30 lbs
-3: 0.15 lbs
-5: 0.01 lbs

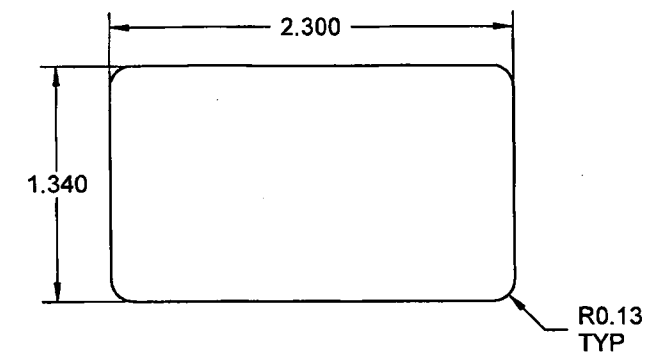
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4416

RELEASED
03/12/15

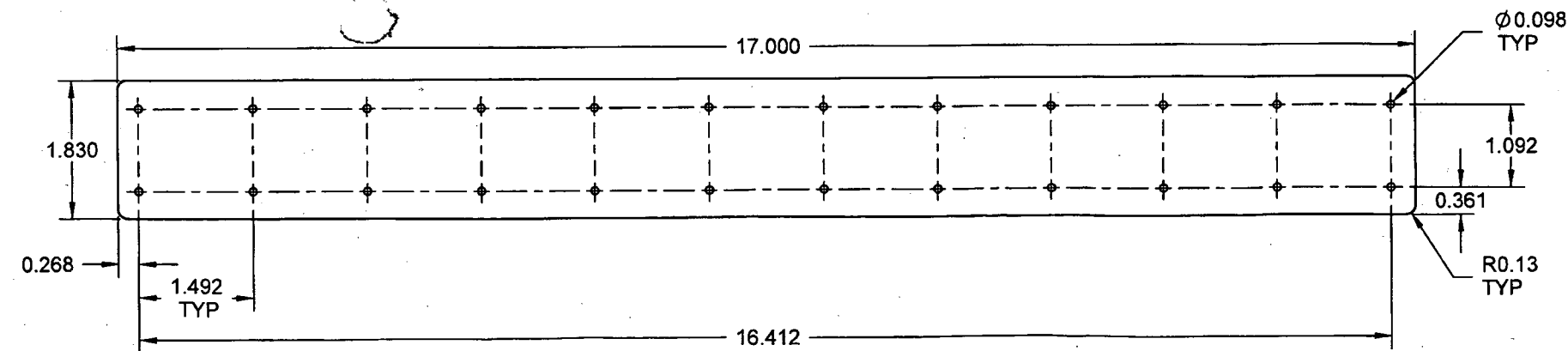
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3234	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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D3234-1 DOUBLER



D3234-5 SPACER



D3234-3 DOUBLER

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WITHOUT NOTICE
WORK ORDER
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RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3234	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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